

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003914**Date Inspected:** 04-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sei Fa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Panels**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

OBG Sub Assembly Bay #1

This QA Inspector observed ZMPC welding personnel performing automated, in gantry, Gas Metal Arc Welding (GMAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP386-001 on Gantry #2. In process GMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed continued Gas Metal Arc Welding (GMAW) tack welding and fit-up of closed rib components to deck plates designated as: DP164-001 and DP440-001.

Magnetic Particle Testing Observation

This QA Inspector observed ZPMC MT personnel perform Magnetic Particle Testing of tack welds in joint fit-up of closed rib PJP welds to deck plate designated as DP164-001. This QA Inspector observed the testing of 190 tack weld locations. ZPMC technicians recorded a total of 31 rejectable indications. Tack weld indication repairs were not initiated and thusly not completed before this QA Inspector ended his shift.

Designation of Radiograph Testing Locations

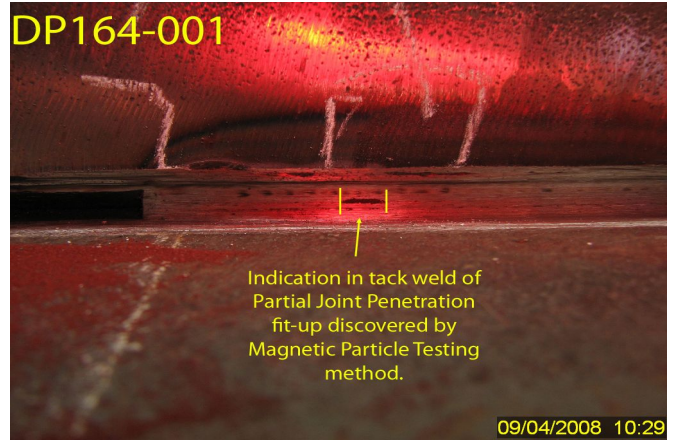
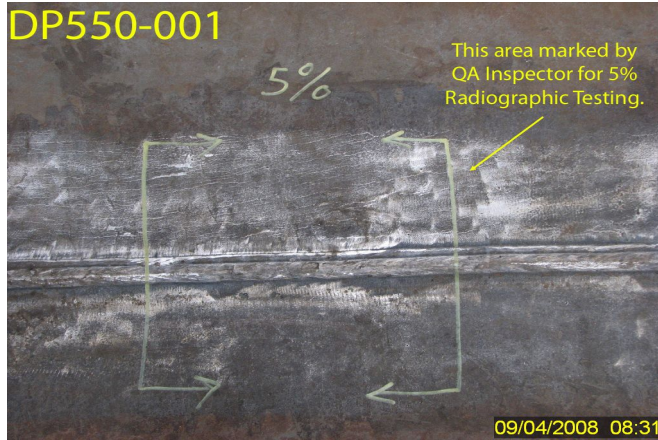
This QA Inspector plotted a total of 5% of weld length for ZPMC subsequent RT testing on deck plate splice welds designated as: DP665-001, DP550-001, DP545-001, and DP595-001.

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Tracking and Log Book

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
